

Work Order ID 69200

Wednesday, May 04, 2011 12:30:25 PM



**PRELIMINARY
ISSUE**

Page 1

Item ID: D4370-043

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Aft Wearplate Assembly

Start Date: 5/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: AA

Date: 11.05.04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4370

PA2

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg (D4370-3)

Dwg Rev: PA2

Prog Rev: PA2

2-Deburr if necessary

0.00

SCRAP

Scrap

B11-5-4

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

POSITIVE
RECALL






B11-5-4



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Item ID:	D4370-043	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Aft Wearplate Assembly					
Start Date:	5/4/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	5/6/2011	Req'd Qty:	1.00		Customer:	
Reference:						






Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 — inspected to Hand written changes on Pad Dry only Sustos (H)							
130  Brake NC Brake NC	Form as per dwg Memo *** Jigs DT8261 and DT8326.***	0.00 0.00 SB 11/05/05							(1)
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							



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Item ID: D4370-043 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Aft Wearplate Assembly
Start Date: 5/4/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 5/6/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Large Fab	Memo 1- on D4371-3, fill cut outs with hardcoat welding rod as per dwg D4370 **DT9756** 2059 B Hardcoat Welding Rod BATCH#: _____ 2-weld D4371-3 to wearplate by positioning holes together as per dwg D4370 304 S.S. Welding Rod BATCH #: _____ 3-Transfer drill holes in bar	0.00 0.00							
160  QC	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
Quality Control									



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Item ID: D4370-043

Accept

Revision ID: PRELIM

Item Name: Aft Wearplate Assembly

Start Date: 5/4/2011 Start Qty: 1.00

Required Date: 5/6/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start






Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
180  Small Fab Small Fab	Small Fab Memo 1- After finish, coat entire top (concave) surface as per note 10 on sheet 2 dwg D4370.	0.00 0.00							
190  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							



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Item ID: D4370-043 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Aft Wearplate Assembly
Start Date: 5/4/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 5/6/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									
210 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

PD 2382

POSITIVE RECALL

EFFECTIVE _____ AUTH 

RELEASED _____ DATE 11/09/04

Picklist Print

Page 1

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Work Order ID: 69200



Parent Item: D4370-043



Parent Item Name: Aft Wearplate Assembly

Start Date: 5/4/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.12 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4371-3		Manufactured	No			150	Each	1.0000	1	1			

Bar

Location	Loc Qty	Loc Code
----------	---------	----------

WA	1	
68410	1	

M304S18GA		Purchased	No			100	sf	129.0000	2.162	2.275789			

304/316 .050 Sheet

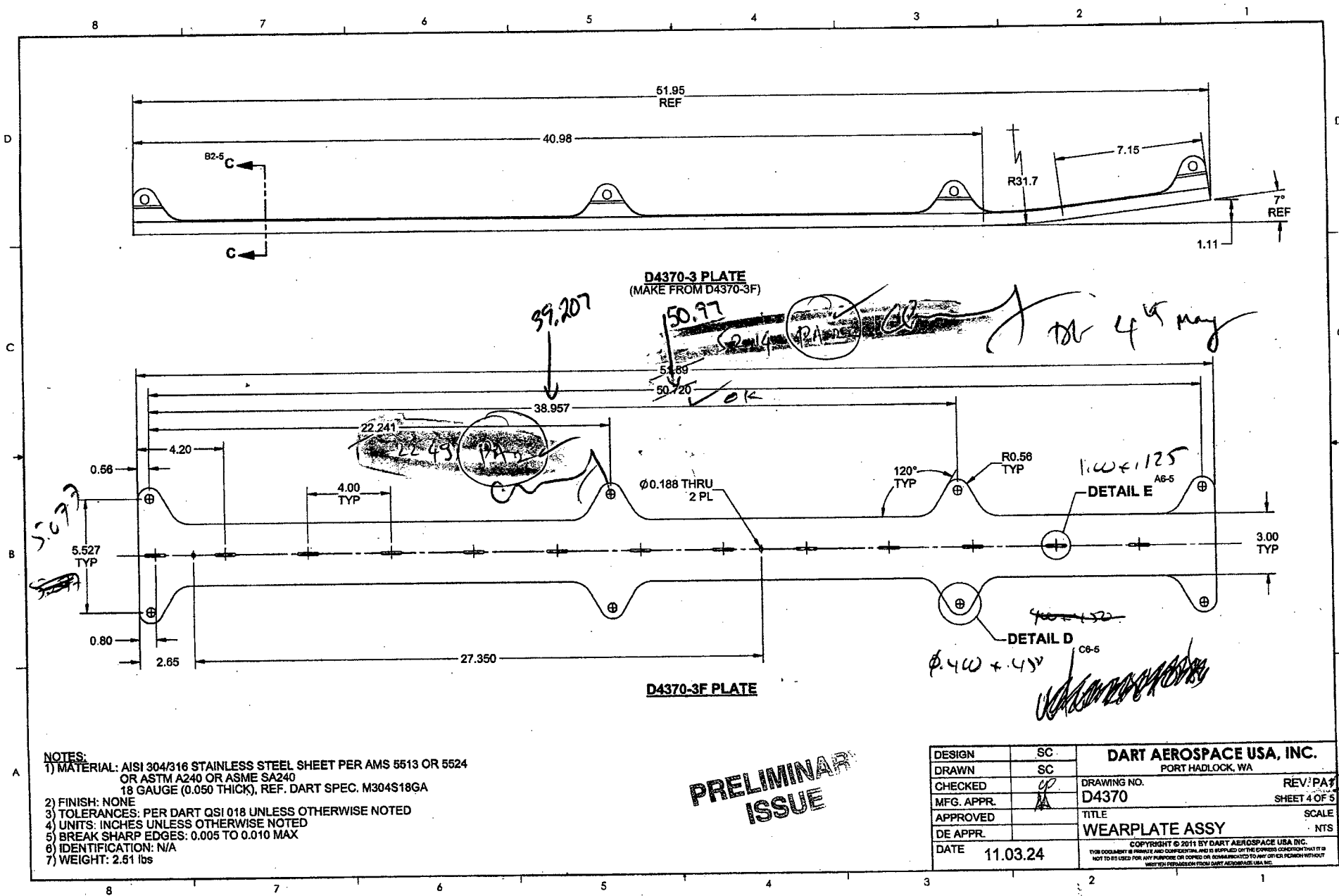
Location	Loc Qty	Loc Code
----------	---------	----------

MAT020	129	
112178	4	
113062	18	
116135	26	
116604	12	
116979	69	

B11-5-4

①

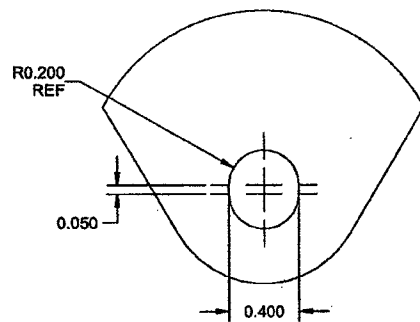
116604



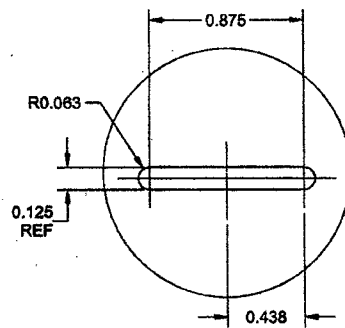
- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.61 lbs

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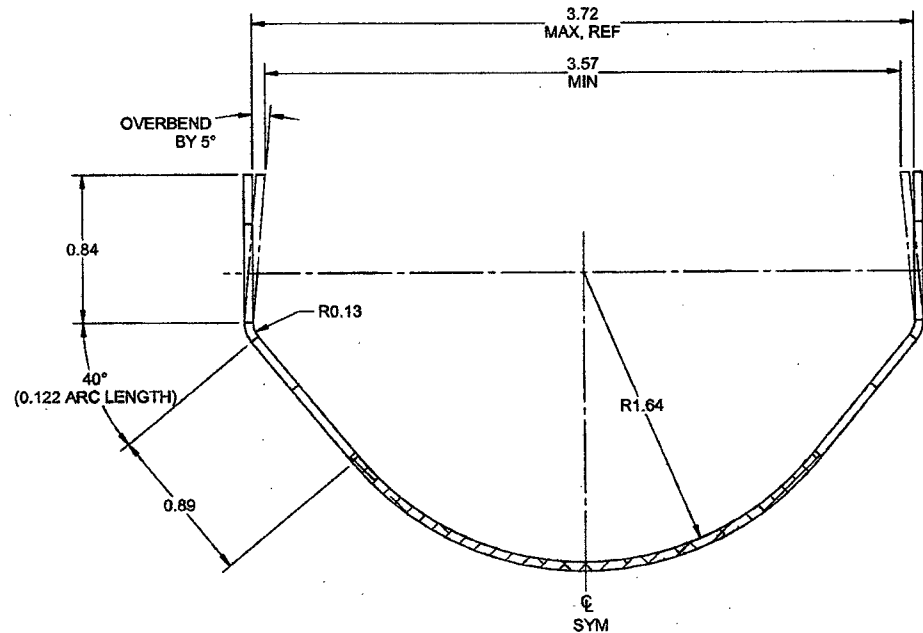
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	UP	DRAWING NO.	REV: PA1
MFG. APPR.		D4370	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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DETAIL D
SLOT DETAIL TYP
B3-3
B2-4



DETAIL E
SLOT DETAIL TYP
B5-3
B1-4



SECTION C-C
D3-3
D7-4

**PRELIMINARY
ISSUE**

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	AP	DRAWING NO.	REV: PA1
MFG. APPR.	AP	D4370	SHEET 5 OF 5
APPROVED	AP	TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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DART AEROSPACE LTD		Work Order: 69200
Description: AFT WEARPLATE ASSEMBLY		Part Number: D4370-043
Inspection Dwg: D4370-3, Rev: PA2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.400	+/- .010	.400	✓		V B02	
.050	+/- .010	.050	✓		V	
.875	+/- .010	.875	✓		V	
.125	+/- .010	.126	✓		V	
3.06	+/- .030	3.010	✓		V	
5.527	+/- .010	5.530	✓		V	
.56	+/- .030	.557	✓		V	
4.20	+/- .030	4.199	✓		V	
2.65	+/- .030	2.65	✓		V	
4.00	+/- .030	4.00	✓		V	
φ .188	+/- .005 - .001	.190	✓		V	
27.350	+/- .010	27.350	✓		T B01	
22.431	+/- .010	22.431	✓		T	
52.14	+/- .030	52.14	✓		T	
28.970	+/- .010				T	
52.300	+/- .010				T	
.056	+/- .010	.050	✓		V	
52.14	+/- .030	52.14	✓			
50.97	+/- .030	50.97			T	
39.207	+/- .010	39.207			T	

Measured by: HB	Audited by:	Prototype Approval:
Date: 11-5-11	Date: 11/05/05	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

to HAD on the chart on PA2 Day